

534

51

DART AEROSPACE LTD	Work Order:	23926
Description: Saddle Spacer	Part Number:	D2885
Drawing: D2885 Rev.A	Qty:	700 120 Multiples of 40

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	AP	05/08/05	100
2	METAL	1 blank makes 4 parts Blank: 7.90" x 3.50" (+0.030" - 0.000") Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick	M 177090 m 17695	4/0 05/08/11	25
3	HAAS	Machine per folio D2885	JL	05.09.3	120
4	QC	Inspect Level 2	JL	05.09.03	120
5	METAL	Tumble	N/A	05/09/05	120
6	METAL	Deburr any rough edges after tumbling	SAD	05/09/25	120
7	METAL	Acid etch and Alodine as per QSI 005 4.1	SAD	05/11/19	120
8	QC	Inspect Level 3	CD	05/11/24	120
9	STORES	Identify and stock	10	05/11/24	120
10	EXPEDITING	Close W/O Cost / part: <u>5.00</u> 05/11/25	120	10 05/11/25	120

Rev	Date	Change	Revised By	Approved
A	99.10.12	New Issue	EC	EC

RELEASED

EC 99.10.12

5.104.5f?

3/21

4.8

M4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

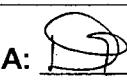
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 05/11/25

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MM	APPROVED	DS	DRAWING NO. D2885
DATE	99.04.01			REV. A SHEET 1 OF 1
				TITLE SADDLE SPACER
A	99.04.01			SCALE 1:1
				NEW ISSUE

RELEASED
99.04.27 DS

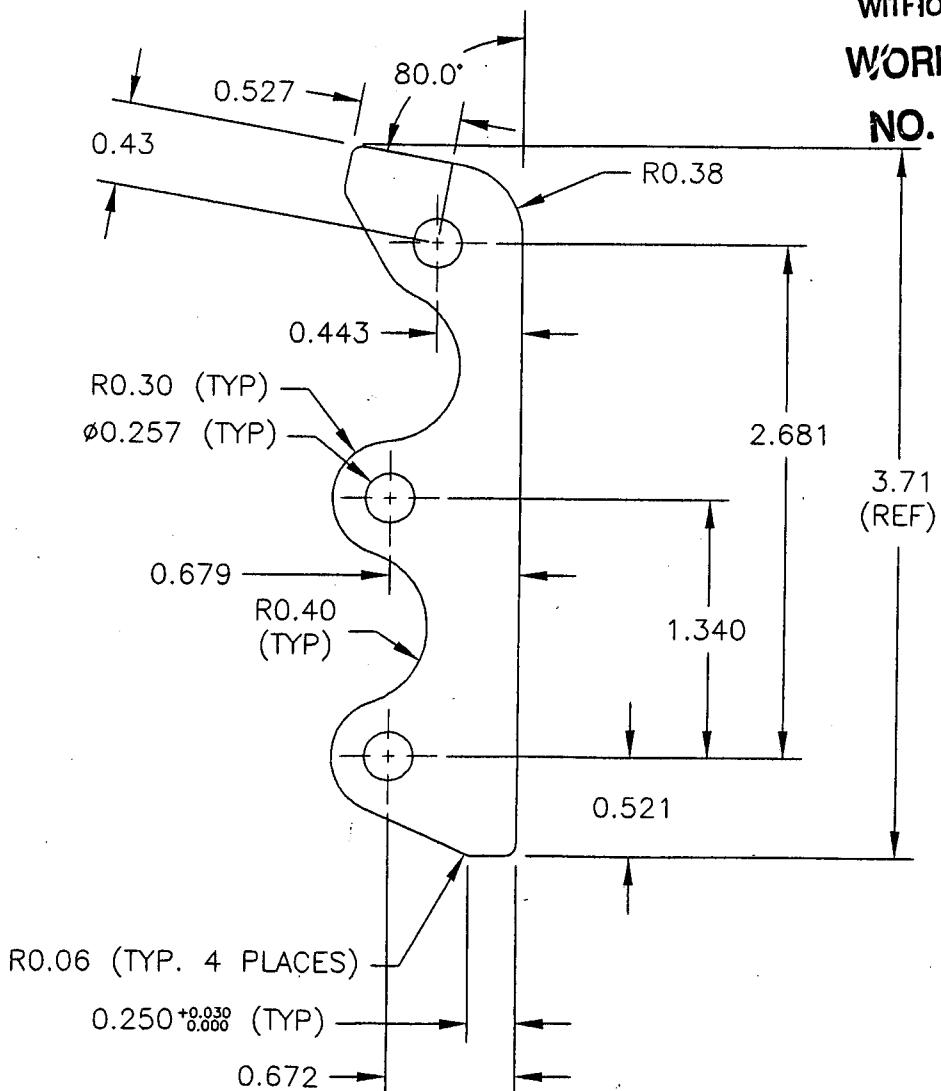
SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23926



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP EDGES 0.010 TO 0.020

000000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No : 0023926
Project Name : D2885
Project For : WK534
Work Order Type : Main
Main WO Number :
House Part Number : D2885
Description : Saddle Spacer
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 08-02-05
Est Finish Date : 08-24-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :
Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	25926
Description: Saddle Spacer	Part Number:	D2885
Inspection Dwg: D2885	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.517"	$\pm .01"$.529"	✓			
.43"	$\pm .03"$.424"	✓			
R.50"	"	.50"	✓			
.443"	$\pm .01"$.443"				
$\varnothing .257"$	$\pm .006"$ $-.001"$.258"	/			
.679"	$\pm .01"$.678"	✓			
R.40"	$\pm .03"$.40"				
R.06	"	.06"	✓			
.25D	$r .03"$ -0	.260"	✓			
.672"	$\pm .01"$.672"	✓			
80°	$\pm 1/2^{\circ}$	80°	✓			
R.38"	$\pm .03$.38"	✓			
3.71"	"	3.701	✓			
2.681"	$\pm .01"$	2.680"	✓			
1.340"	"	1.341"	✓			
.521"	"	.522"	✓			

Measured by:	<i>PS</i>	Audited by:	<i>ES</i>	Prototype Approval:	<i>N/A</i>
Date:	<i>05/09/02</i>	Date:	<i>05/09/03</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	